

Work Order ID 79295

79295

Page 1

January-24-12 1:54:18 PM

Item ID: D3187-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod Floor

Start Date: 24/01/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/02/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/01/24

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3187

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3187

Dwg Rev: C

Prog Rev: C 2-

Deburr if necessary

6661.052

2 0 Jan 12-6-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

TEMPLATE DT3187-1T1

2 0 Jan 12-6-15

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Salvatis

(+2)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 07/02/2012 Req'd Qty: 2.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

2 2/6 12-6-18

140 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M121279

32001

1:45

2:15

2X 4 M/L 12/06/18

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

2 4 BL 12-6-18

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 Start Date: 24/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Small Fab	Small Fab	0.00							
Small Fab	Memo 1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187A/R, contact cement Batch: <u>112983</u> 2- transfer holes from spacepod floor to rubber spacer	0.00		<u>13-08-27</u>		<u>2</u>			
170 *170* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00		<u>13.8.29</u>		<u>2</u>			
180 *180* Packaging	Identify as per dwg & Stock Location: <u>81241-A</u>	0.00							
Packaging	Memo	0.00				<u>2x</u>		<u>8P</u> <u>13-8-29</u>	

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/9/30
P/B-08-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-24-12 1:54:22 PM

Page 1

Work Order ID: 79295

79295

Parent Item: D3187-2

D3187-2

Parent Item Name: Spacepod Floor

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C05.04.14 Now a purchased part KJ/JLM
IPP Rev:D Now on Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.C as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2986-1		Manufactured	No			110	Each	2.0000	1	2			

D2986-1

Rubber Spacer

**

2 ~~13~~ 13-08-27

Location	Loc Qty	Loc Code
ST242	2	
60770	2	

M6061T6S.050

Purchased No

160 sf

119.3600

7.43

15.64211 / 2

M6061T6S 050

6061-T6 .050 Sheet

**

Jim 12-6-15

Location	Loc Qty	Loc Code
MAT021	119.36	
113216	15	
114799	89.36	
114993	15	

121192

114799 (7.825 SF)

121192 (7.825 SF)

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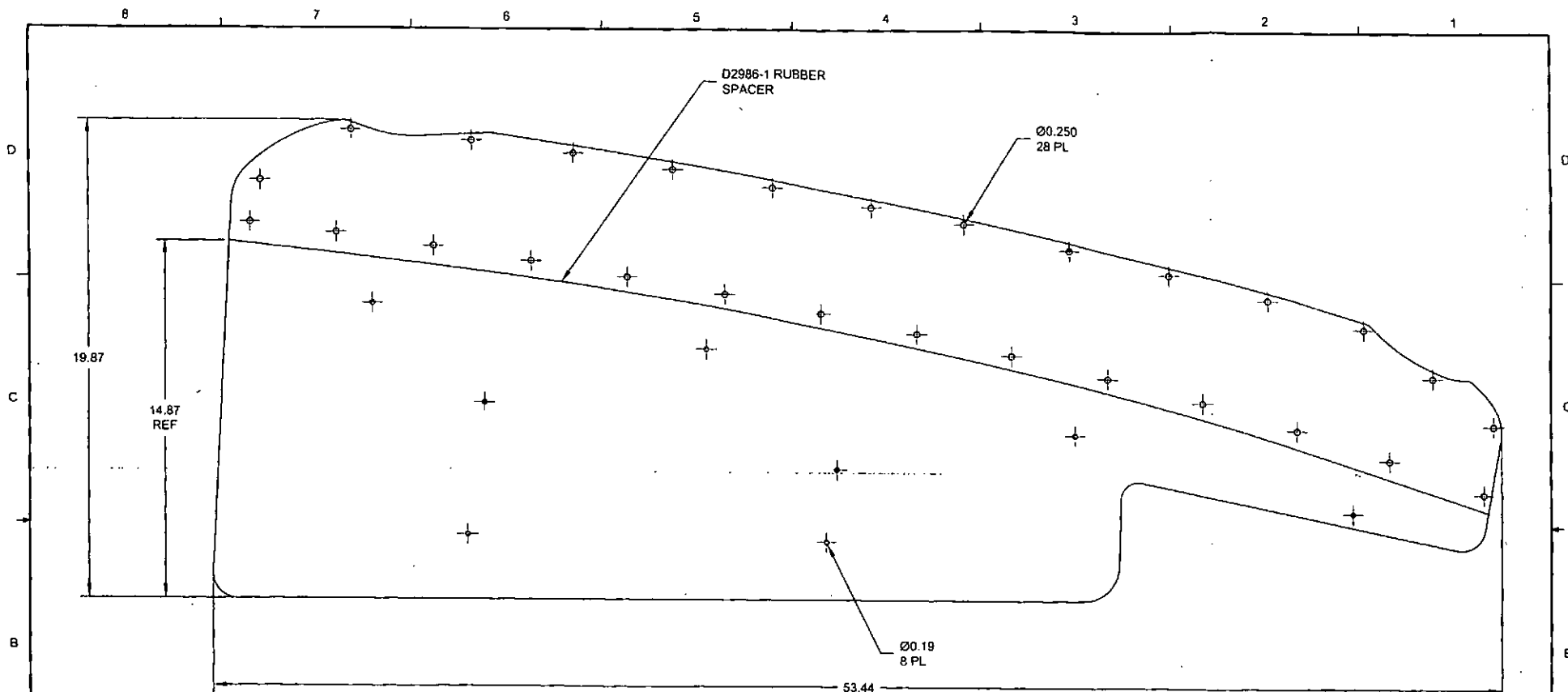
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D3187-1 SPACEPOD FLOOR

RELEASED
09-01-05 MB

D3187-1 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER
NO. 79295 H.L.S
12/01/24

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/2.	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3187
REV. C
SHEET 1 OF 2

TITLE SPACEPOD FLOOR
SCALE NTS

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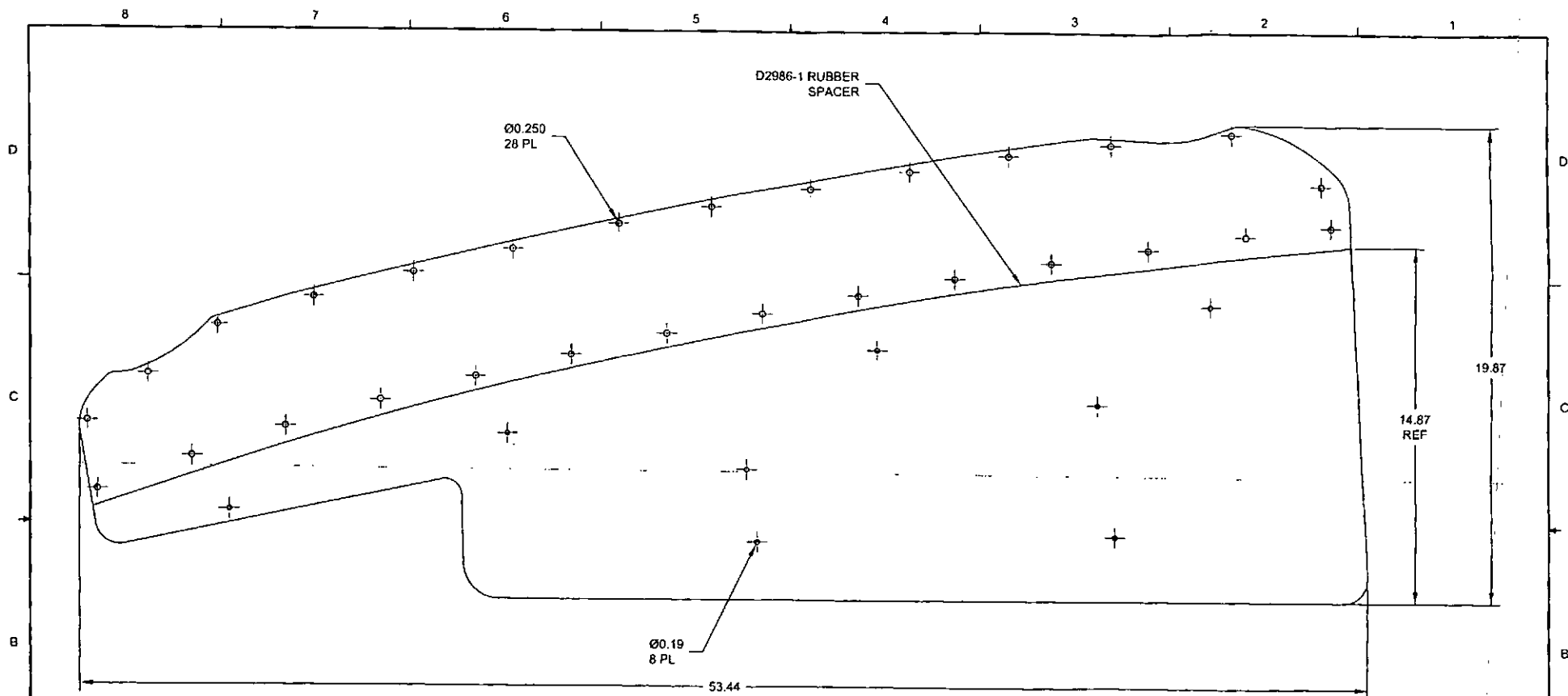
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D3187-2 SPACEPOD FLOOR

D3187-2 SPACEPOD FLOOR NOTES:

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- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
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- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09-01-05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3187	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CAN BE RELEASED ON THE UNLESS OTHERWISE NOTED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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